

Date: Friday, 2/23/2007 8:32:50 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 30901	
Estimate Number : 10713	
P.O. Number : <u>N/A</u>	Part Number : D3213041
This Issue : 2/23/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3213 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : <u>A</u>
Previous Run : 30640	Material : <u>N/A</u>
Written By : _____	Due Date : 3/14/2007 Qty: 4 Um: Each
Checked & Approved By : <u>07.02.23</u>	
Comment : Est Rev. A New Issue 05-11-17 17:27	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D3161-3	Hinge	

B23189 x 4 + 2  
B28287 x 4

✓  
 PTO

2.0	D32131	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-1	Door	<u>B 30656</u>

✓

3.0	D32133	Door Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-3	Door	<u>B 30657</u>

✓

4.0	MS20470AD44	Rivet, Universal Head
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
24	MS20470AD4-4	Rivet	<u>M102328</u>

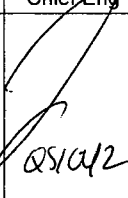

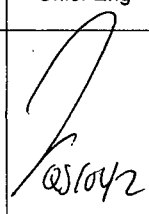

✓

ml 07/03/13

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 02/04/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/13	1	Scrap 2 D#3161-3 (15" hinge) "Bad Tooling" ml	 05/04/12	Destroy & replace. Use new drill jig.	ml 07/03/13	 07/03/14	 05/04/12	 07/03/14

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30901

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

ml 07/03/13 x4

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-14 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M18316  
ml 00700 M-R 07/03/30 (X)  
Ful/M-R 07/03/14 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-03-19 (4)

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2137 Decal ~~15-1-1368~~

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2419 Handle B 29745 -

11.0

D2462

Neoprene Seal



Comment: Qty.: 2.4000 f(s)/Unit Total : 9.6000 f(s)


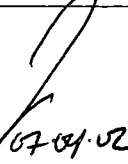
Pick: Assembly Kit

Qty Part Number Description Batch

2 D2462 Seal B 30878 -

mf 07-03-19

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-04-08	15	Had to replace rivet + washer. Made hole bigger (Had to remove old rivet and it made the hole larger) A0M520470AD56 <del>6-02-2008</del> M9619, AN960308 M103492	MF	07-02-04	1		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/04/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:32:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30901

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D27281

Dart Logo label small



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2728-1 Decal B24915

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN960JD6 Washer M6085

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet M865 IM 103641 -

MF 07-03-19

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

MF 07-04-02 (4)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PC 7/4/03 (4)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 07/04/04 (4)

Job Completion



U 87-May

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

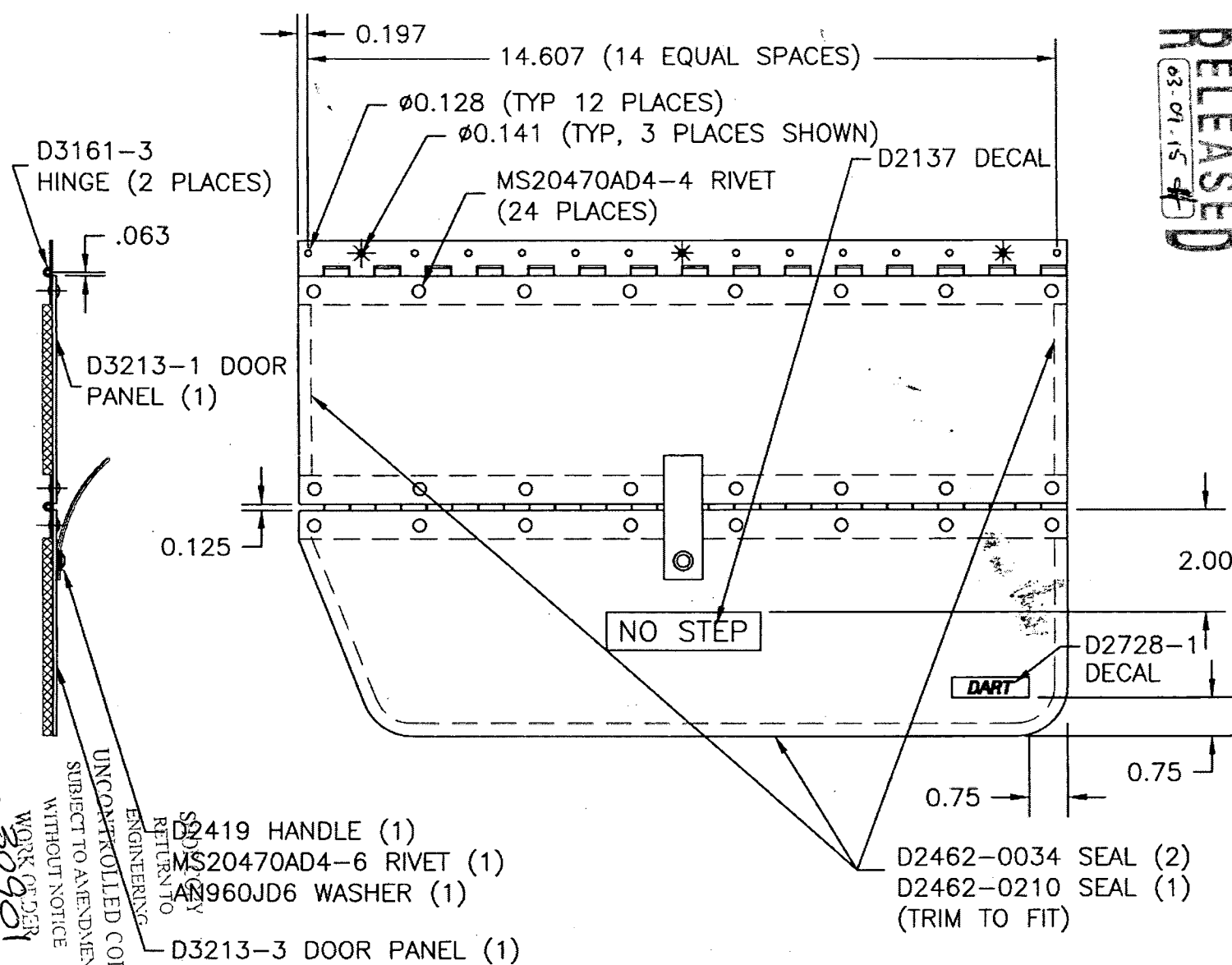
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3213
DATE	TITLE	REV. A
03.09.03	DOOR ASSEMBLY	1 OF 2
A	03.09.03	SCALE
	NEW ISSUE	1:3

RELEASED  
03-01-15-40



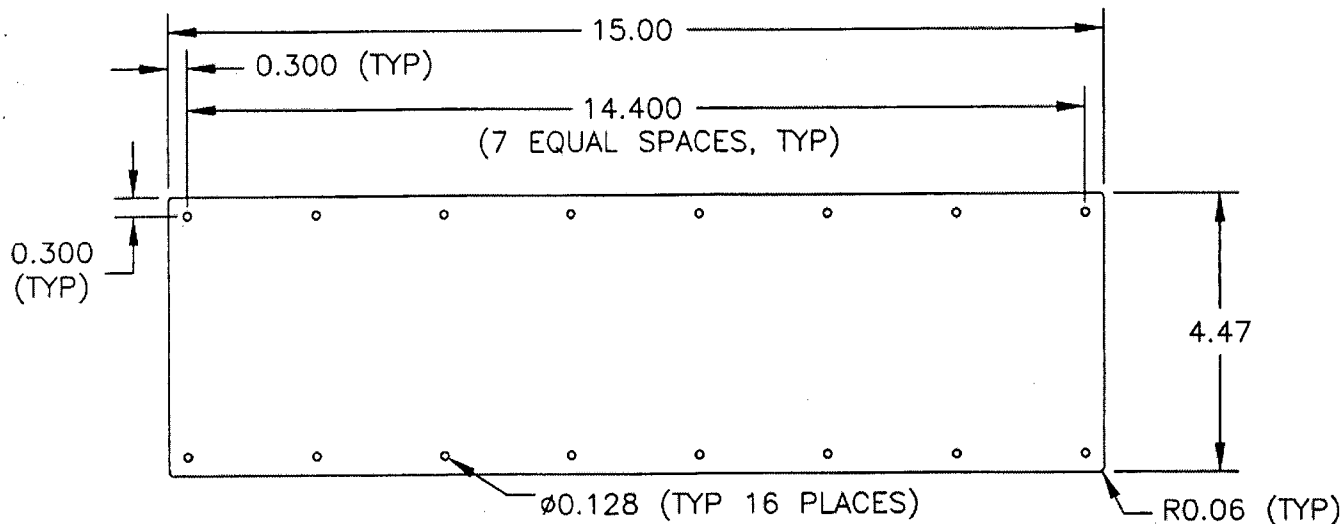
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
30901

**D3213-041 DOOR ASSEMBLY**

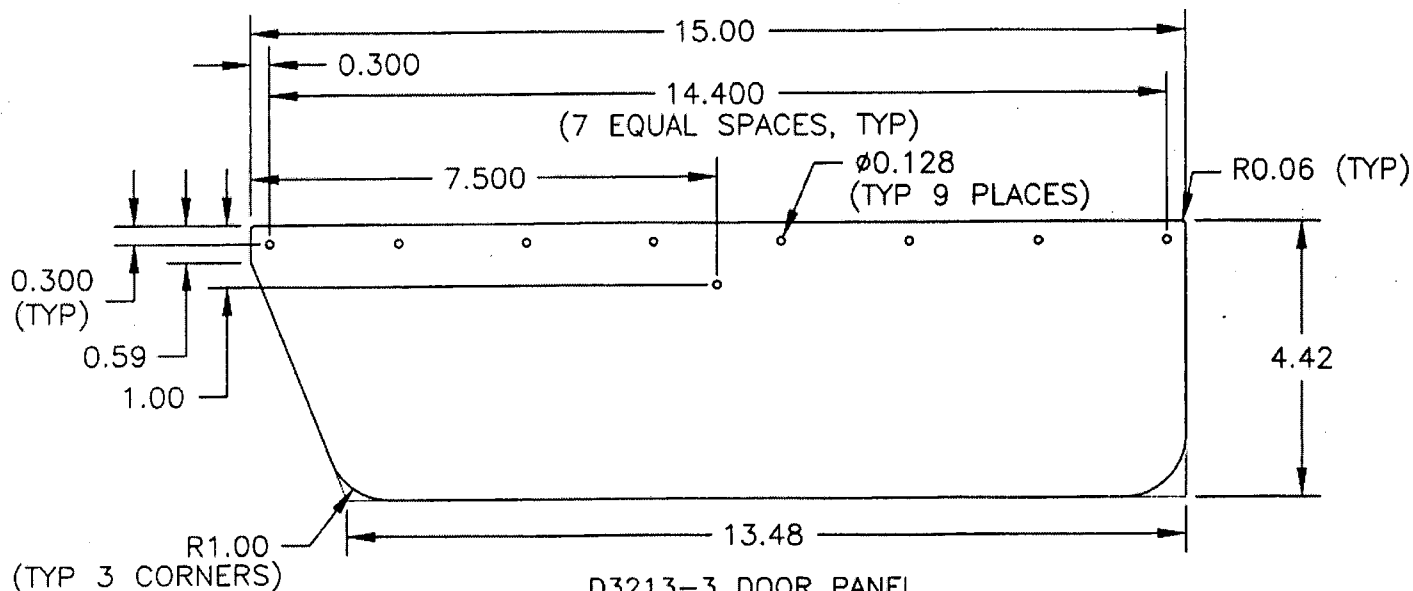
FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE  
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
03.09.03

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 30701

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